

Work Order ID 51428



Page 1

August 24, 2009 10:44:25 AM

Item ID: D2230-3

Accept



Setup Start



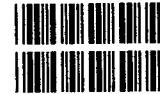
Revision ID: G

Stop



Item Name: Lug

Start Date: 24/08/2009 Start Qty: 200.00



Cust Item ID:

Required Date: 28/08/2009 Req'd Qty: 200.00



Customer:

Reference:

Approvals: Process Plan: MP Date: 09-09-24 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D2230	Rev G	

100



BAND SAW

Bandsaw

Jeaspa Bandsaw

0.00

MP 09/08/26

200

S

0.00

Band Saw Cut D2423 extrusion to 0.82" Batch: 45800

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

0.00

200

S

0.00

Machine per folio D2230-3 Check for crack while loading into the machine.SL/H.A
09/09/16

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

SL/H.A 14/09.09.25
09/09/16

200

S

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Cust Item ID:

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Customer:

Reference: 24/08/2009

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Quality Control

Memo

0.00

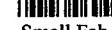
~~QC8- Inspect parts - second check~~
and 09/09/28

~~200~~ 200 ✓

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Tumble and deburr rough edges after tumbling

LD 09/09/29

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

11 09/09/30

(X200) 6

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Page 3

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Cust Item ID:

Required Date: 28/08/2009 Req'd Qty: 200.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC3- Inspect Part Finish

0.00

200/09/30

(200)

f

QC

Quality Control

170



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

200/09/30

(200)

A

Powdercoat

Powder Coating

Memo

START TIME: 11:15pm OVEN TEMPERATURE:
FINISH TIME: 320°F

180



QC3- Inspect Part Finish

0.00

0.00

200/09/10/01

(200)

QC

Quality Control

Memo

DART AEROSPACE LTD	Work Order:	
Description: Mounting Lug	Part Number:	D2230-3
Inspection Dwg: D2230 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>JL</u>	Audited by:	<u>SM</u>	Prototype Approval:	N/A
Date:	<u>09/09/16</u>	Date:	<u>09/09/16</u>	Date:	

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	57568
Description: Mounting Lug	Part Number:	D2230-3
Inspection Dwg: D2230 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article Prototype

~~REFERENCE ONLY~~

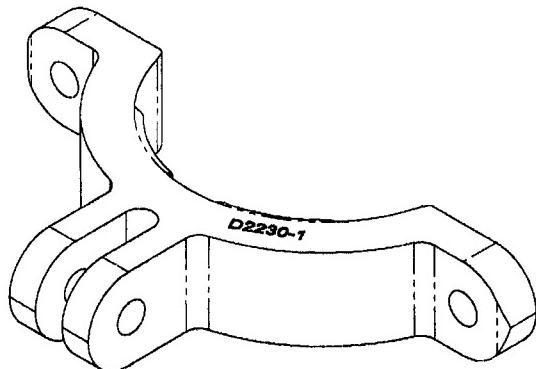
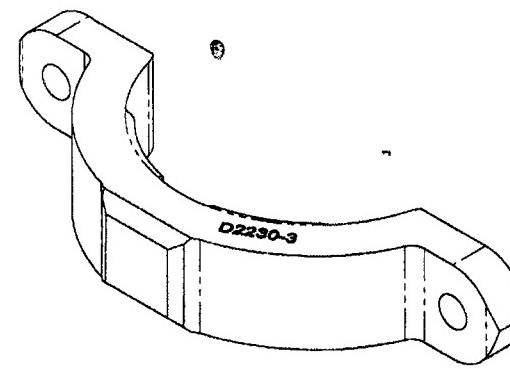
Measured by:	H.A	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	09/09/09	Date:	09/09/16	Date:	

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF	PF

8 7 6 5 4 3 2 1

D

D

D2230-1 MOUNTING LUGD2230-3 MOUNTING LUG

S1428

RELEASED
07/07/5M

B

B

G

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005 .
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

A

8 7 6 5 4 3 2 1

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.			AJS	09.01.16
F	REDESIGN: R1.200 WAS 1.100			CP	09.12.13
E	RE-DESIGN			BW	05.01.04
D	RE-DESIGN			BW	05.01.04
C	RE-DESIGN			BW	04.03.30
REV.	DESCRIPTION			BY	DATE
DESIGN	BW	DART AEROSPACE LTD			
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA			
CHECKED	A	DRAWING NO. D2230			REV. G
MFG. APPR.	<i>[Signature]</i>	SHEET 1 OF 3			
APPROVED	<i>[Signature]</i>	TITLE MOUNTING LUG			SCALE NTS
DE APPR.	<i>[Signature]</i>				
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD			
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